

Date: Monday, 6/5/2006 7:41:11 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOOR
<b>Job Number</b> : 27344	
<b>Estimate Number</b> : 12266	
<b>P.O. Number</b> : <i>NIA</i>	<b>Part Number</b> : D3140106
<b>This Issue</b> : 6/5/2006 <b>S.O. No.</b> : <i>NIA</i>	<b>Drawing Number</b> : D3140 REV D1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>NIA</i> <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D1
<b>Previous Run</b> : 25738	<b>Material</b> : <i>NIA</i>
<b>Written By</b> : <i>See Comment Below</i>	<b>Due Date</b> : 6/30/2006
<b>Checked &amp; Approved By</b> : <i>06.06.05 N</i>	<b>Qty:</b> 4 <b>Um:</b> Each
<b>Comment</b> : Est Rev:A New Issue 06-02-08 JLM Est. Rev B New dwg rev. ecn781 06.04.18 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M2024T3S032	2024-T3 .032 sheet
-----	-------------	--------------------



**Comment:** Qty.: 0.0578 sf(s)/Unit Total: 0.2310 sf(s)  
 2024-T3 .032 " Thick sheet  
 (M2024T3S032) *m18447*  
 Batch: *ml 06/06/09*

2.0	SHEAR	SHEAR
-----	-------	-------



**Comment:** SHEAR  
 Cut Blanks 2.45" x 3.13 as per Dwg D3140

*ml 06/06/09*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2-Cut Angle as per Dwg D3140

*SB ml 06/06/09*

4.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE

*06/06/09*  
 Form as per Dwg D3140

*SB 06/06/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
<del>06/06/12</del>	<del>4</del>	<del>Add debur before bending.</del>					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 06/06/15

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:41:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 27344

Part Number: D3140106

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



*June 6 2006* (04)



Comment: INSPECT WORK TO CURRENT STEP

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*HM 06/06/14* (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*DL 06/06/14*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DL 06/06/14* (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*DL 06/06/14* (4)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DL 06/06/15* (4)

Job Completion



*DL 06/06/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN DS	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	<del>06.03.31</del>	1.75 WAS 1.88; 4.75 WAS 4.13	

RELEASED  
05.12.01 *[Signature]*

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27344

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23	TITLE DOOR	SCALE NTS	

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

**RELEASED**  
05.12.01

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

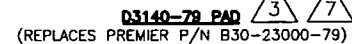
RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27344

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





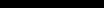




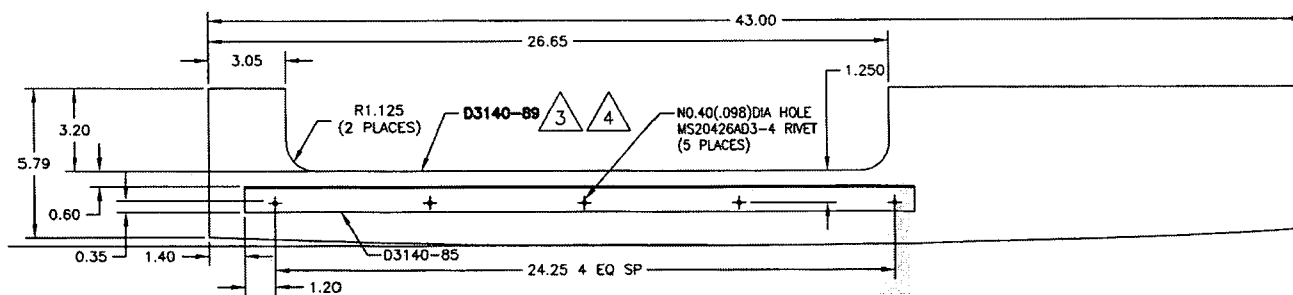
RELEASED  
05-12-01



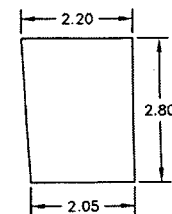
Three triangles are shown, labeled 1, 2, and 3 from left to right.

**D3140-71 PAD**    
(REPLACES PREMIER P/N B30-23000-71)

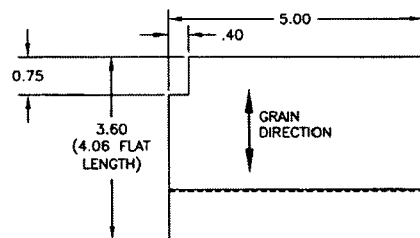
COPYRIGHT © 2002 BY DART AEROSPACE LTD.  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	DESIGN	DRAWN BY	 <b>DART AEROSPACE LTD.</b> HAMILTON, ONTARIO, CANADA	
	DS	RF		
	CHECKED 	APPROVED 	DRAWING NO.	REV. D
DATE		D3140	SHEET 4 OF 7	
05.11.23		TITLE	SCALE	
		DOOR	NTS	



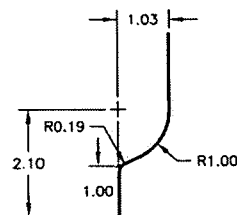
**D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)**  
**D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)**



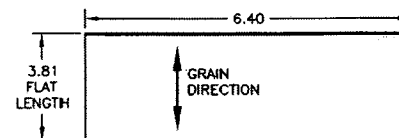
**D3140-101 DOUBLER** (REPLACES PREMIER P/N B30-23000-101)



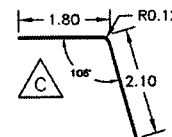
**D3140-91F FLAT PATTERN**  
 (USE TO MAKE D3140-91/-92 DOUBLERS)



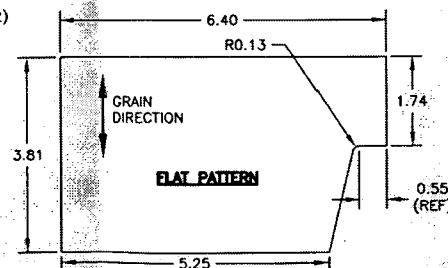
**D3140-91 DOUBLER** (SHOWN, REPLACES PREMIER P/N B30-23000-91)  
**D3140-92 DOUBLER** (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



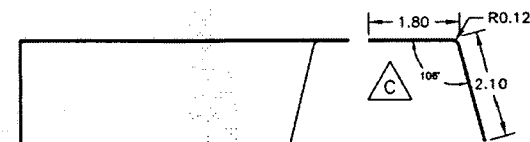
**D3140-95 DOUBLER** (REPLACES PREMIER P/N B30-23000-95)



**RELEASED**

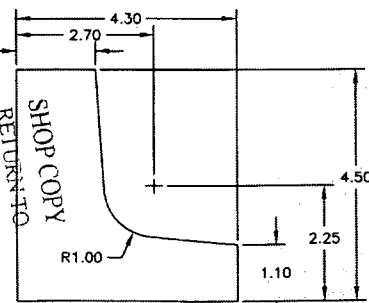


**D3140-97F FLAT PATTERN**  
 (USE TO MAKE D3140-97/-98 DOUBLERS)



**BEND DETAIL**

**D3140-97 DOUBLER** (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER** (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)



**D3140-99 DOUBLER** (REPLACES PREMIER P/N B30-23000-99)

NO. 27364

WORK ORDER  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN DS

CHECKED

DATE 05.11.23

DRAWN BY RF

APPROVED

**DART**

DRAWING NO. D3140

TITLE DOOR

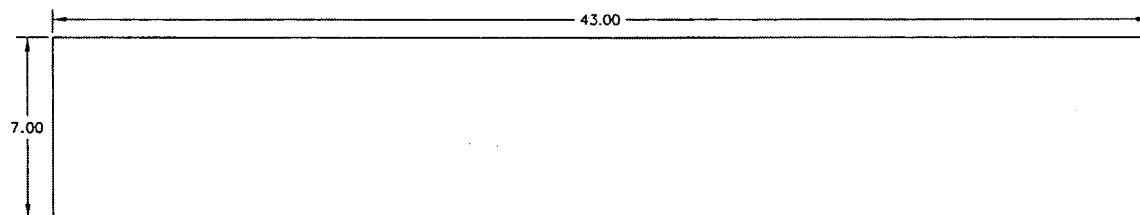
DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA

REV. 0

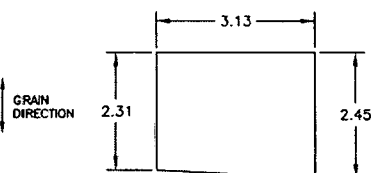
SHEET 5 OF 7

SCALE

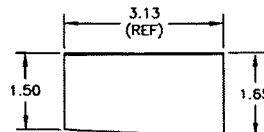
NTS



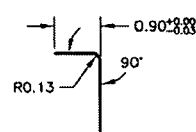
**D3140-87 DOUBLER**  $\triangle 4$   
(REPLACES PREMIER P/N B30-23000-87)



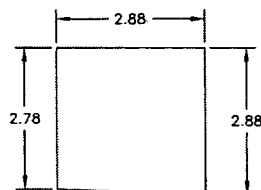
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)



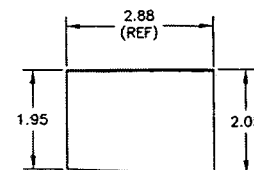
**D3140-105 DOUBLER**  $\triangle 4$   $\triangle D$   
**D3140-106 OPPOSITE**



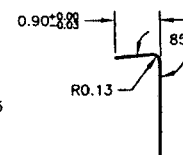
GRAIN DIRECTION



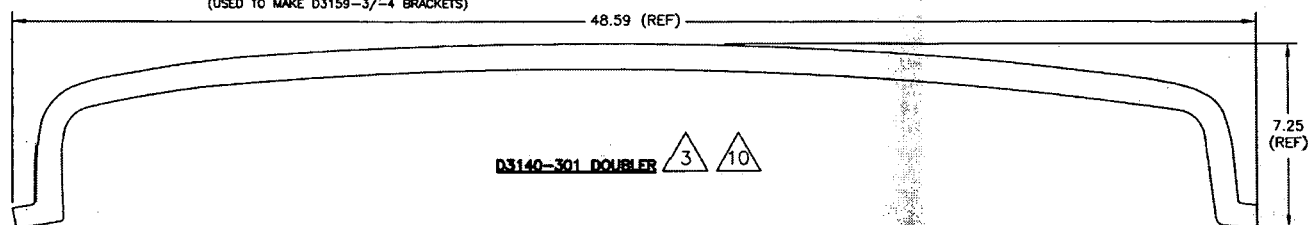
**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)



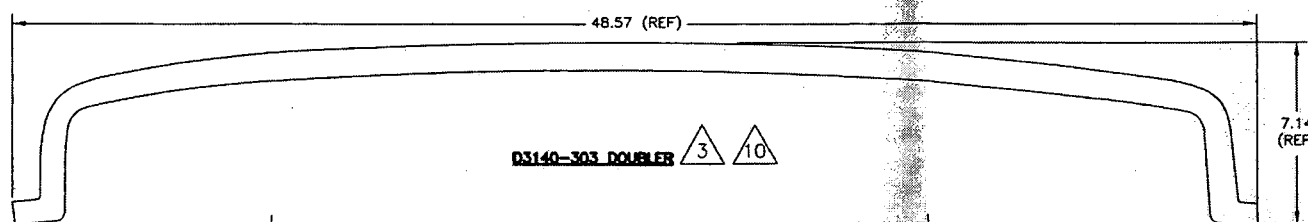
**D3140-103 DOUBLER**  $\triangle 4$   $\triangle D$   
**D3140-104 OPPOSITE**



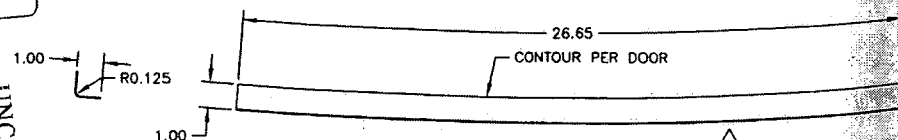
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**  $\triangle 3$   $\triangle 10$



**D3140-303 DOUBLER**  $\triangle 3$   $\triangle 10$



**D3140-85 ANGLE**  $\triangle 6$   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

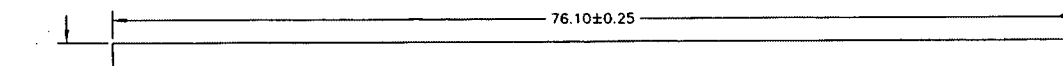
RELEASED  
05.11.01

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

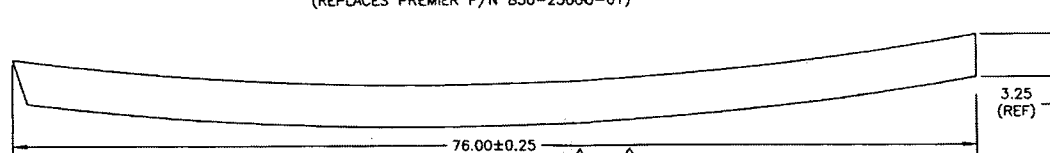
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN DS	DRAWN BY RF	<b>DART</b>	DART AEROSPACE LTD. WINNIPEG, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3140	REV. D SHEET 6 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

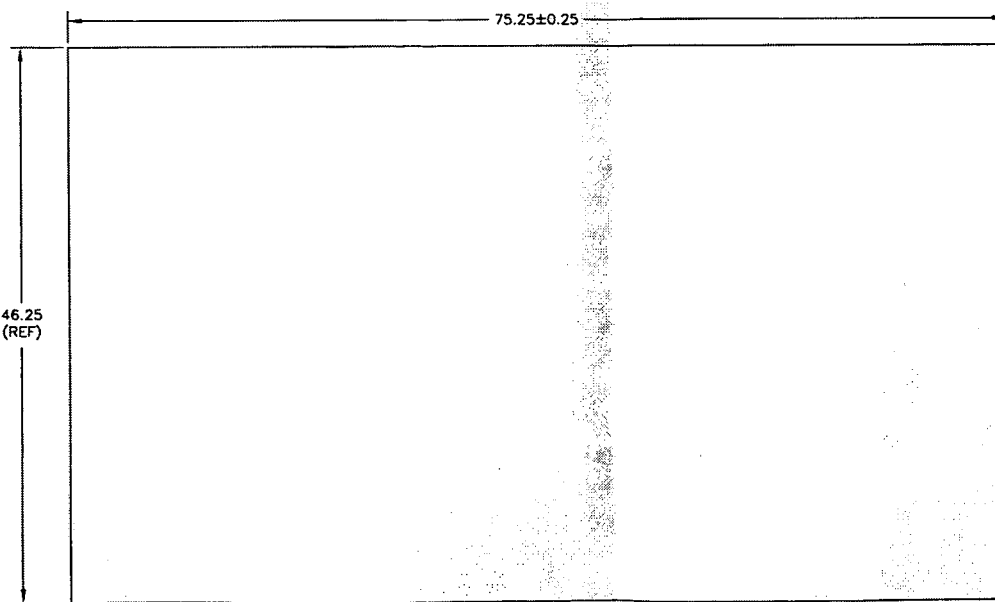
NO. 27344  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
SUBJECT TO AMENDMENT



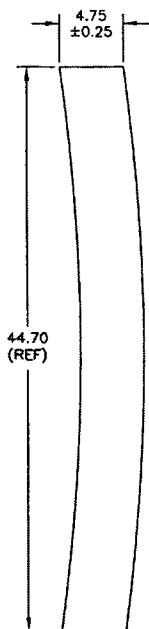
**D3140-61 PAD** 3 7  
(REPLACES PREMIER P/N B30-23000-61)



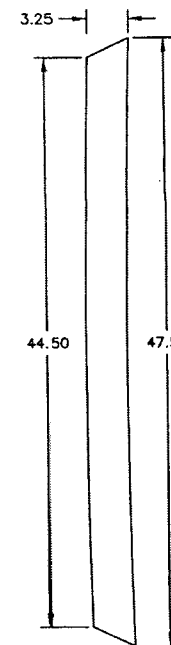
**D3140-63 PAD** 3 7  
(REPLACES PREMIER P/N B30-23000-63)



**D3140-59 PAD** 7  
(REPLACES PREMIER P/N B30-23000-59)



**D3140-57 PAD**  
(REPLACES PREMIER P/N B30-23000-57)  
3 7



**D3140-241 DOUBLER** 5  
(REPLACES PREMIER P/N B30-23000-241)

**RELEASED**  
05.11.23

R1.00  
(2 PLACES, REF)

COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN DS	DRAWN BY RF	<b>DART</b> DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	REV. 0
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	SHEET 7 OF 7
		DATE 05.11.23	TITLE DOOR		SCALE NTS

NO. 27344  
WORK ORDER  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE